

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003942**Date Inspected:** 29-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** AB/F Wang Heng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

**OBG Assembly Bay II**

5AE- QA observed tack welding by the SMAW process at floor beam FB13A to bottom plate BP110 and BP56A. QA also observed that the welder was about to weld over paint and QA queried AB/F QC personnel Wang Heng as to what he was going to do about this potential incident. Mr. Heng mentioned that he would have the paint and detritus removed in the joint prepped areas and that the three previous tack welds produced over paint would be removed. QA observed prior to leaving the location that the above mentioned grinding of said tacks welds was commencing.

QA was approached by ZPMC representative Mr. Testino and he produced a copy of D1.5 (2002) and mentioned that ZPMC considered the paint to be a light rusty prohibitive coating. QA mentioned that this was a situation to be elevated to his superiors and that his argument could not be resolved at this QA inspectors level. However, QA did mention that the paint associated with this process was .....paint and will produce hydrogen which will in turn potentially damage and reduce the quality of any weldment and indeed cause cracking induced by the hydrogen.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

The above mentioned items as observed by QA and field resolved by AB/F, ZPMC appear to be in conformance with the contract documents.



### Summary of Conversations:

See above for situational specific conversation summaries.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Vatcher,Robert
----------------------	----------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Cuellar,Robert
---------------------	----------------

QA Reviewer
-------------